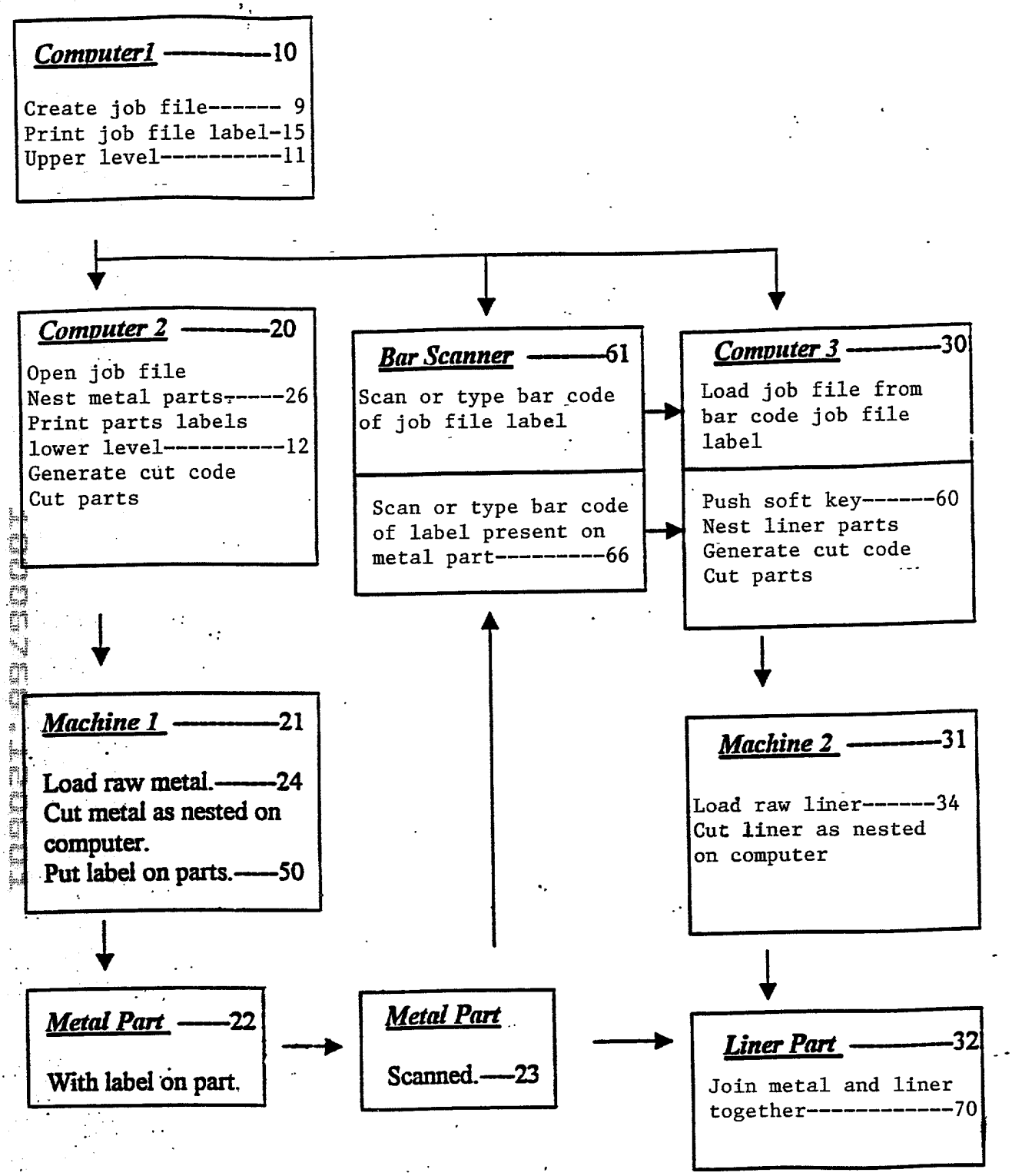
Fig. 1


Computer1 ——10
Create job file------ 9
Print job file label-15
Upper level----------11
Computer 2 ——20
Open job file
Nest metal parts-----26
Print parts labels
lower level----------12
Generate cut code
Cut parts
Bar Scanner ——61
Scan or type bar code of job file label
Scan or type bar code of label present on metal part---------66
Computer 3 ——30
Load job file from bar code job file label
Push soft key------60
Nest liner parts
Generate cut code
Cut parts
Machine 1 ——21
Load raw metal.——24
Cut metal as nested on computer.
Put label on parts.——50
Machine 2 ——31
Load raw liner------34
Cut liner as nested on computer
Metal Part ——22
With label on part.
Metal Part
Scanned.——23
Liner Part ——32
Join metal and liner together----------70